

Work Order ID 121272

June-20-14 12:46:03 PM

121272

Page 1

Item ID: D350-636-101

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Toe Step

Start Date: 6/20/14 Start Qty: 12.00

12

Cust Item ID:

Required Date: 6/24/14 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3487

Rev A

100

Document Control

0.00

DAS
06
9-89

100

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPPD350-636-101 CHG001

JUL 22 2014

12

110

0.00

110

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg *** D3487-1***

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

DAS
23
9-89

12

0

14-06-22

6061.100"

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Page 2

Item ID: D350-636-101

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Toe Step

Start Date: 6/20/14 Start Qty: 12.00

12

Cust Item ID:

Required Date: 6/24/14 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC2- Inspect parts off machine FAI/FAIB	0.00							DAS 23 9-89
120						12	0		14-06-22
QC	Memo	0.00							
Quality Control									
130	QC8- Inspect parts - second check	0.00							DAS 27 9-89
130						(12)			
QC	Memo	0.00							
Quality Control									
150	NC BRAKE	0.00							
150						12			14/07/09
Brake NC	Memo	0.00							
Brake NC	Form as per Dwg D3487								

Work Order ID 121272

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121272

Page 3

Item ID: D350-636-101

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Toe Step

Start Date: 6/20/14 Start Qty: 12.00 ***12***

Cust Item ID:

Required Date: 6/24/14 Req'd Qty: 12.00 ***12***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC5- Inspect part completeness to step on W/O	0.00	DAS	27		12			
160				9-89					
QC	Memo	0.00		14719					
Quality Control									
170	Chemical Conversion Coat per QSI005 4.1	0.00				12			
170									
HandFinish	Memo	0.00							
Hand Finishing									
180	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00				12			
180									
Powdercoat	Memo	0.00							
Powder Coating									
START TIME: <u>2:25</u> FINISH TIME: <u>2:55</u> OVEN TEMPERATURE: <u>320</u>									

DAS 34 9-89

Work Order ID 121272

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121272

Page 5

Item ID: D350-636-101

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Toe Step

Start Date: 6/20/14 Start Qty: 12.00

12

Cust Item ID:

Required Date: 6/24/14 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

NR1

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

230

QC21- Final Inspection - Work Order Release

0.00

230

QC

Memo

0.00

Quality Control

14/7/23 *[Signature]*
MF
14-7-23

Picklist Print

June-20-14 12:46:02 PM

Page 1

Work Order ID: 121272

121272

Parent Item: D350-636-101

D350-636-101

Parent Item Name: Toe Step

Start Date: 6/20/14

Required Date: 6/24/14

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 06-03-03 JLM
11.03.15 now made in house DD verf:JLM

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.100		Purchased		No		110	sf	89.3000	0.7942	11			DAS
M6061T6S 100									**				23 9-89
6061-T6 .100 Sheet													14-06-22

Location

Loc Qty

Loc Code

MAT021

89.3

m128315

47.1

m129165

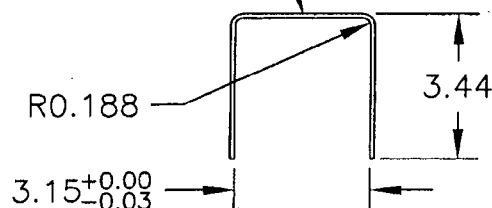
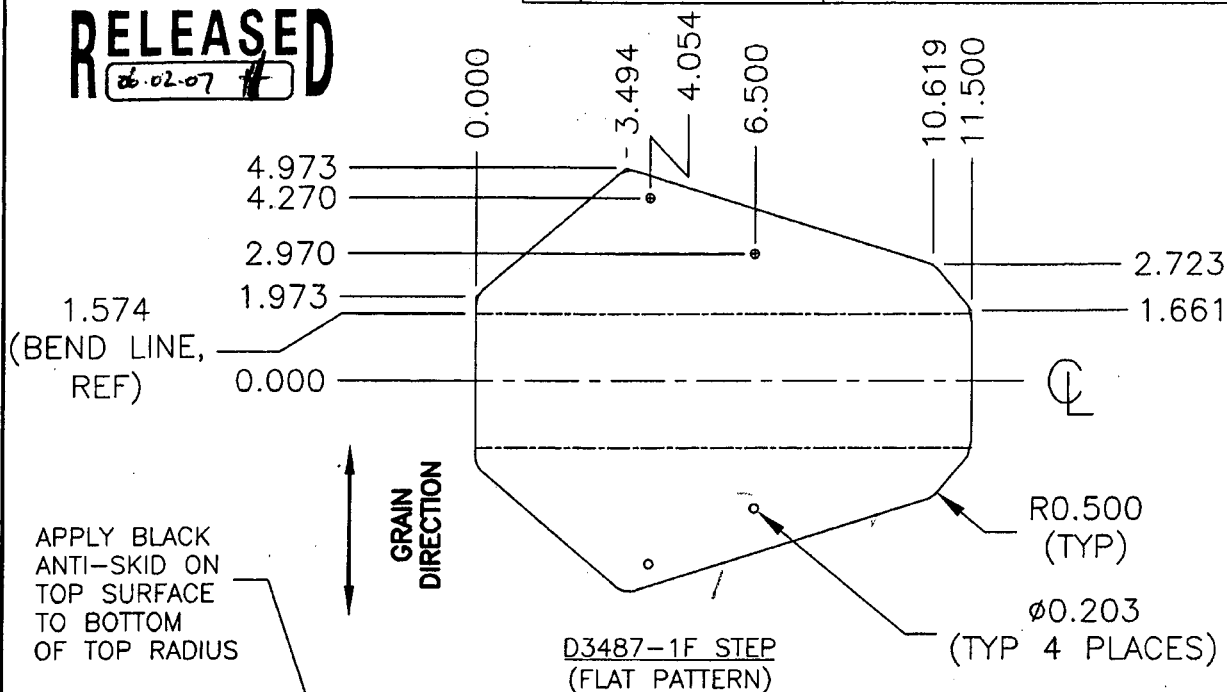
42.2

129165.



DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3487	REV. A SHEET 1 OF 1
DATE 06.01.16		TITLE STEP	SCALE 1:4
A	06.01.16	NEW ISSUE	

RELEASED
06.02.07



D3487-1 STEP
(BENDING DETAIL)

D3487-1 STEP

- 1) MATERIAL: ALUMINUM 6061-T6/T651 ALUMINUM (QQ-A-250/11) 0.100 THICK
(REF DART MATERIAL SPEC M6061T6S.100)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT TO TOP SURFACE PER DART QSI 005 4.4
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) PART IS SYMMETRICAL ABOUT CENTERLINE
- 6) BREAK UNMARKED EDGES 0.005 TO 0.010 MAX

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Page 1

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B121272

Item ID: D350-636-101

Revision ID:

Item Name: Toe Step

Start Date: 6/20/14

Start Qty: 12.00

12

Required Date: 6/24/14

Req'd Qty: 12.00

12

Reference:

Accept

N9000040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
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Accept
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Reject
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Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3487

Rev A

100

Document Control

0.00

100

DC

DOCUMENT CONTROL

Memo 2

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPPD350-636-101 CHG001

ML5 140722

12

110

0.00

110

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg *** D3487-1***

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

12 0 DAS 23 14-06-27 0.00

6061.100"